









Date: Wednesday, 3/21/2007 3:42:03 PM  
User: Kim Johnston

# Process Sheet

|  |   |
|--|---|
| Customer : CU-DAR001 Dart Helicopters Services         | Drawing Name : DOOR ASSEMBLY                  |
| Job Number : 31410                                     |   |
| Estimate Number : 10714                                |   |
| P.O. Number :  | Part Number : D350567015                      |
| This Issue : 3/21/2007 S.O. No. :                      | Drawing Number : D3213 REV A                  |
| Prsht Rev. : NC  | Project Number : N/A                          |
| First Issue : / / Type : SMALL /MED FAB                | Drawing Revision : A                          |
| Previous Run : 2410                                    | Material :                                    |
| Written By : <u>[Signature]</u>                        | Due Date : 4/15/2007 Qty: <u>(9)</u> Um: Each |
| Checked & Approved By : <u>[Signature] 01.03.22</u>    |   |
| Comment : Est Rev:B Removed Manufacturing 05-11-17 JLM |   |

## Additional Product

Job Number: 

| Seq. #:   | Machine Or Operation:   | Description :   |
|---|---|---|
| 1.0   | DC  | DOCUMENT CONTROL  |
|   |    |    |
| Comment: DOCUMENT CONTROL<br>Photocopy bluefile and create labels & DT8439 TEMPLATE per PPP D350-567-015 CHG001 <u>CL</u> 07.04.02  |   |   |
| 2.0   | D2137   | Decal - No Step   |
|   |  |  |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)<br>Pick: Assembly Kit<br>Qty Part Number Description Batch<br>1 D2137 Decal <u>24358</u> X   |   |   |
| 3.0   | D2419   | Handle  |
|   |  |  |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)<br>Pick: Assembly Kit<br>Qty Part Number Description Batch<br>1 D2419 Handle <u>24374</u> N <u>(6)</u> <i>mangue 4</i>             |   |   |
| 4.0   | D2462   | Neoprene Seal   |
|   |  |  |
| Comment: Qty.: 0.6825 f(s)/Unit Total : 6.8250 f(s)<br>Pick: Assembly Kit<br>Qty Part Number Description Batch<br>2 D2462-3.9" Seal <u>B24456</u> <u>(9)</u> <i>N/A 900</i> <i>7/03/26 Se</i> |   |   |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Drawing Name: DOOR ASSEMBLY

Job Number: 31410

Part Number: D350567015

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D27281

Dart Logo label small



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

2 D2728-1

Decal

B2425

6.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 AN960JD6

Washer

M6085

7.0

MS20470AD4-6

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 MS20470AD4-6

Rivet

M102929

8.0

D2462

Neoprene Seal



Comment: Qty.: 1.9250 f(s)/Unit Total : 19.2497 f(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 D2462-22.0"

Seal

B2425

7/03/28

59

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3212 & D3213 Note: Ensure decals are firmly attached to panel/window

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Drawing Name: DOOR ASSEMBLY

Job Number: 31410

Part Number: D350567015

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

12.0

D2125

350/355 Floor Window

X



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2125 Floor Window

B24100 X

B 23817

4X +

13.0

D2126

Seal



Comment: Qty.: 5.2500 f(s)/Unit Total : 52.5000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2126-60.0" Seal

B24668

B 27452

14.0

D2463

1/2" Seal



Comment: Qty.: 3.7500 f(s)/Unit Total : 37.5000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2463-45.0" Neoprene Seal

B26934

3/5 from 27 45" D24660

15.0

D32101

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3210-1 Doubler

B 30899

B 23068

16.0

D32111

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3211-1 Bracket

B 30899

B 23068

02/03/29 S9

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Drawing Name: DOOR ASSEMBLY

Job Number: 31410

Part Number: D350567015

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

D32121

Floor Window



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D3212-1

Floor Window

~~5~~ ~~B32688~~ ~~B32693~~ ~~B32694~~ ~~B32695~~ ~~B32696~~ ~~B32697~~ ~~B32698~~ ~~B32699~~ ~~B32700~~ ~~B32701~~ ~~B32702~~ ~~B32703~~ ~~B32704~~ ~~B32705~~ ~~B32706~~ ~~B32707~~ ~~B32708~~ ~~B32709~~ ~~B32710~~ ~~B32711~~ ~~B32712~~ ~~B32713~~ ~~B32714~~ ~~B32715~~ ~~B32716~~ ~~B32717~~ ~~B32718~~ ~~B32719~~ ~~B32720~~ ~~B32721~~ ~~B32722~~ ~~B32723~~ ~~B32724~~ ~~B32725~~ ~~B32726~~ ~~B32727~~ ~~B32728~~ ~~B32729~~ ~~B32730~~ ~~B32731~~ ~~B32732~~ ~~B32733~~ ~~B32734~~ ~~B32735~~ ~~B32736~~ ~~B32737~~ ~~B32738~~ ~~B32739~~ ~~B32740~~ ~~B32741~~ ~~B32742~~ ~~B32743~~ ~~B32744~~ ~~B32745~~ ~~B32746~~ ~~B32747~~ ~~B32748~~ ~~B32749~~ ~~B32750~~ ~~B32751~~ ~~B32752~~ ~~B32753~~ ~~B32754~~ ~~B32755~~ ~~B32756~~ ~~B32757~~ ~~B32758~~ ~~B32759~~ ~~B32760~~ ~~B32761~~ ~~B32762~~ ~~B32763~~ ~~B32764~~ ~~B32765~~ ~~B32766~~ ~~B32767~~ ~~B32768~~ ~~B32769~~ ~~B32770~~ ~~B32771~~ ~~B32772~~ ~~B32773~~ ~~B32774~~ ~~B32775~~ ~~B32776~~ ~~B32777~~ ~~B32778~~ ~~B32779~~ ~~B32780~~ ~~B32781~~ 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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



Date: Wednesday, 3/21/2007 3:42:03 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 31410

Part Number: D350567015

Job Number:



Seq. #:

Machine Or Operation:

Description:

23.0

MS20470AD47

Rivet, Universal Head



Comment: Qty.: 20.0000 Each(s)/Unit Total: 200.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

20 MS20470AD4-7

Rivet

415924-75

M100854 105

24.0

MS21042L06

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 MS21042L06

Nut

M100993

25.0

DT8439

D350-567 CuttingTemplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 DT8439

CuttingTemplate

REV.B

26.0

FG778150550ROL

7781 9oz Glass 50"x125yd



Comment: Qty.: 10.7600 sf(s)/Unit Total: 107.6000 sf(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1m<sup>2</sup>020A0127

Cloth #144-9oz

M101039

07/02/27 SH

27.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

07/06/06 (9)

C207/06/06 (9)

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-567-015

Location:

PPP Rev:

Draft

07/06/06 (9)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/13

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Wednesday, 3/21/2007 3:42:03 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 31410

Part Number: D350567015

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC21

FINAL INSPECTION/W/O RELEASE



07.06.13 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*u* 07.06.13

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

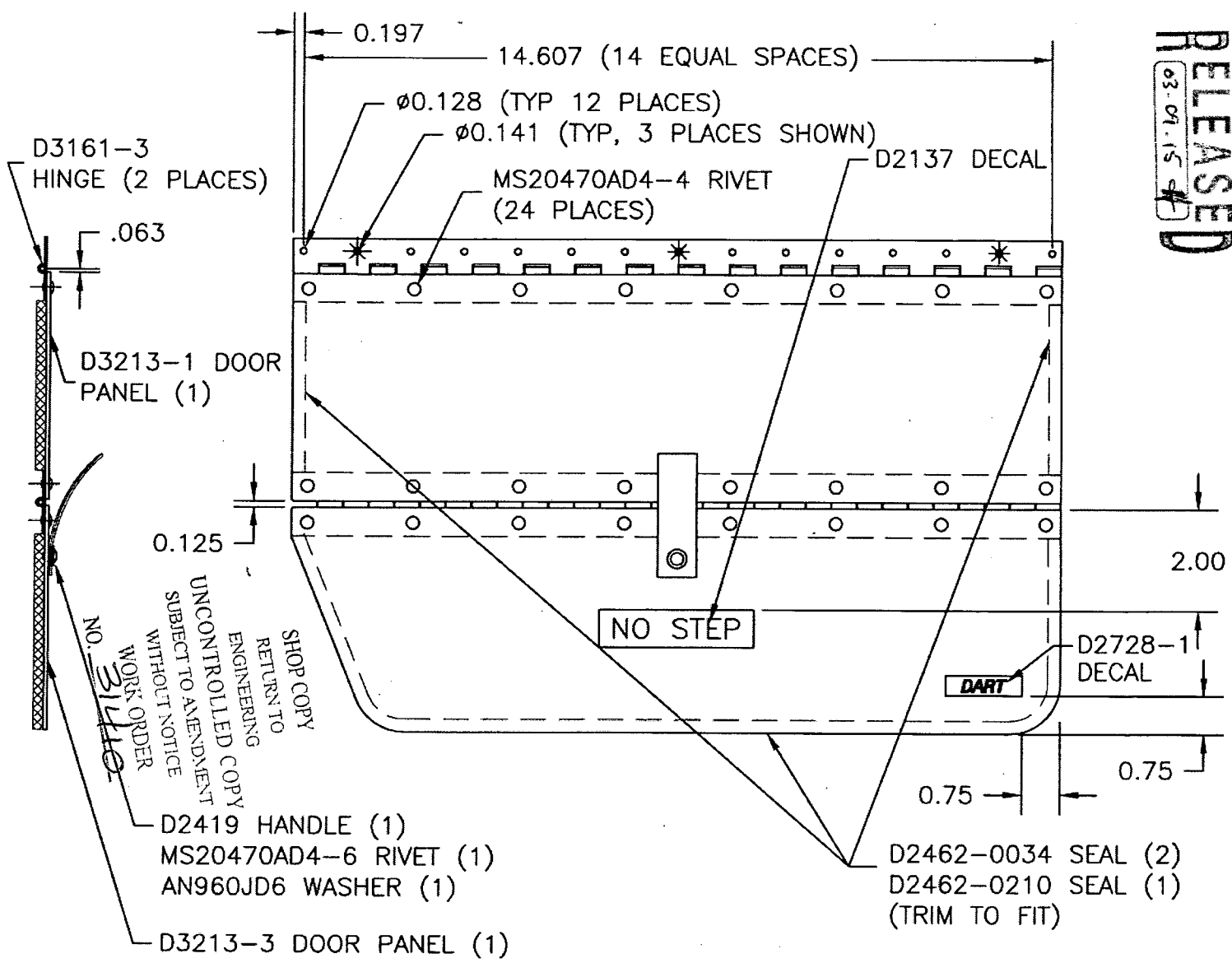
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|         |          |             |               |                             |
|---------|----------|-------------|---------------|-----------------------------|
| DESIGN  | CP       | DRAWN BY    | CP            | DART AEROSPACE LTD          |
| CHECKED | ✓        | APPROVED    | ✓             | HAWKESBURY, ONTARIO, CANADA |
| DATE    | 03.09.03 | DRAWING NO. | D3213         | REV. A                      |
|         |          | TITLE       | DOOR ASSEMBLY | 1 OF 2                      |
| A       | 03.09.03 | NEW ISSUE   |               | SCALE 1:3                   |

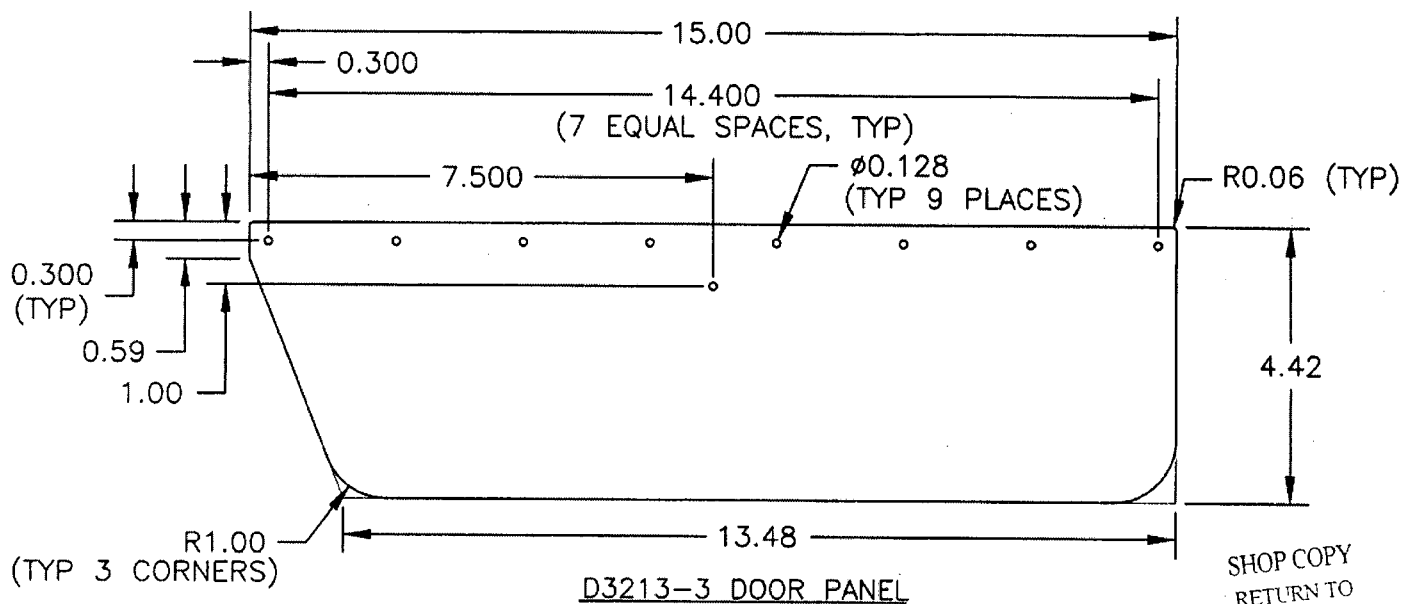
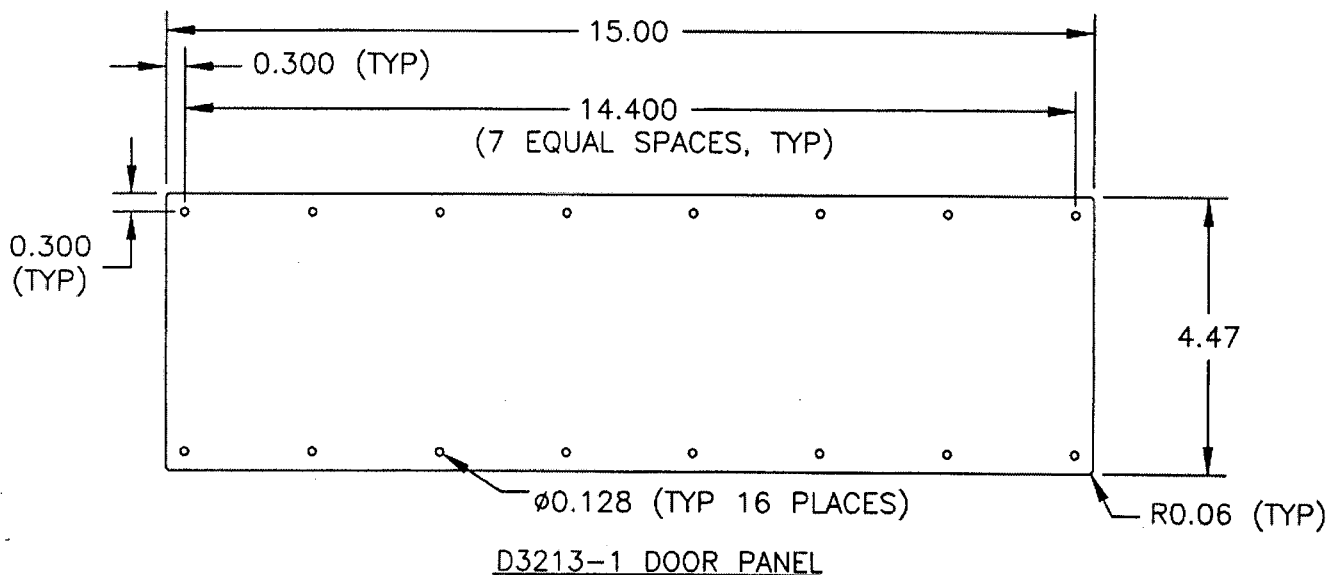
RELEASED  
03.01.15



**D3213-041 DOOR ASSEMBLY**  
FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE  
FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3  
INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



|                               |                                |   |                  |
|-------------------------------|--------------------------------|---|------------------|
| DESIGN<br><i>CP</i>           | DRAWN BY<br><i>CP</i>          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                  |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3213                              | REV. A<br>2 OF 2 |
| DATE<br>03.09.03              |                                | TITLE<br>DOOR ASSEMBLY                            | SCALE<br>1:3     |



D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WORK ORDER  
NO. 31410

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